

Date: Wednesday, 3/15/2006 3:42:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X16")
Job Number	: 26251		
Estimate Number	: 10320		
P.O. Number	: N/A	Part Number	: K10007
This Issue	: 3/15/2006 S.O. No. : N/A	Drawing Number	: D2435 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: E1
Previous Run	: 25289	Material	: N/A
Written By	: <u>SRE COMMENT BELOW</u>	Due Date	: 3/22/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>06.03.16</u>		
Comment	: Est Rev:C 04.02.17 Blank size changed KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile: K10007

D206-559

D500-572

D120-638

D058-678

and create labels per PPP K10005 CHG003

(Bag Bluefiles separately)

Jmk 06/04/01 10

2.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 4.5491 sf(s)/Unit Total : 45.4913 sf(s)

blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3

Material: Black UHMW 1"

(MUHMWB10)

Batch: M17726

Jmk 06/04/01 10

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2435 Identify as D2435

3-Deburr

Jmk 06/04/03 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 06/04/03 10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/04/03 10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.4160 f(s)/Unit Total: 4.1600 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion *B24870*

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block *B25769*

2 D2435(ref only) Bearpaw *B26251*

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp *D25015 11mcp*

B20963B 3mcp B25611 26mcp

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Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529

Washer

1325372 ~~625372~~

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M19085

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-17A

Bolt

M19471

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M19085

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 ✓

Nut (or -4)

M19098

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/05
 QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S Clamp M19554

1 Paperwork package ✓

Rev 4/4/04 (10)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C206104/04 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPk10007

Location: _____

REV.E

C206104/04 (10)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/05 (10)

Job Completion



W 06-04-05

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<u>26251</u>
Description: Bearpaw		Part-Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.057x45°	—			
B	5.500	+/-0.030	5.501	—			
C	0.200	+/-0.030	0.196	—			
D	R0.250	+/-0.030	R0.250	—			
E	0.250	+/-0.010	0.242	—			
F	0.625	+/-0.030	0.614	—			
G	0.25 x 45°	+/-0.030	0.240x45°	—			
H	0.375	+/-0.010	0.385	—			
I	19.000	+/-0.030	19.000	—			
J	0.950	+0.030/-0.010	0.956	—			
K	Ø0.260	+0.005/-0.000	Ø0.260	—			
L	Ø0.930	+/-0.030	Ø0.930	—			
M	0.30	+0.030/-0.000	0.305	—			
N	0.375	+/-0.030	0.385	—			
O	7.375	+/-0.030	7.375	—			
P	4.250	+/-0.010	4.250	—			
Q	2.000	+/-0.030	2.000	—			
R	9.000	+/-0.010	9.000	—			
S	15.750	+/-0.030	15.750	—			

Measured by:	<u>JML</u>	Audited by:	<u>EP</u>	Prototype Approval:	N/A
Date:	<u>06/04/02</u>	Date:	<u>06/04/02</u>	Date:	<u>N/A</u>

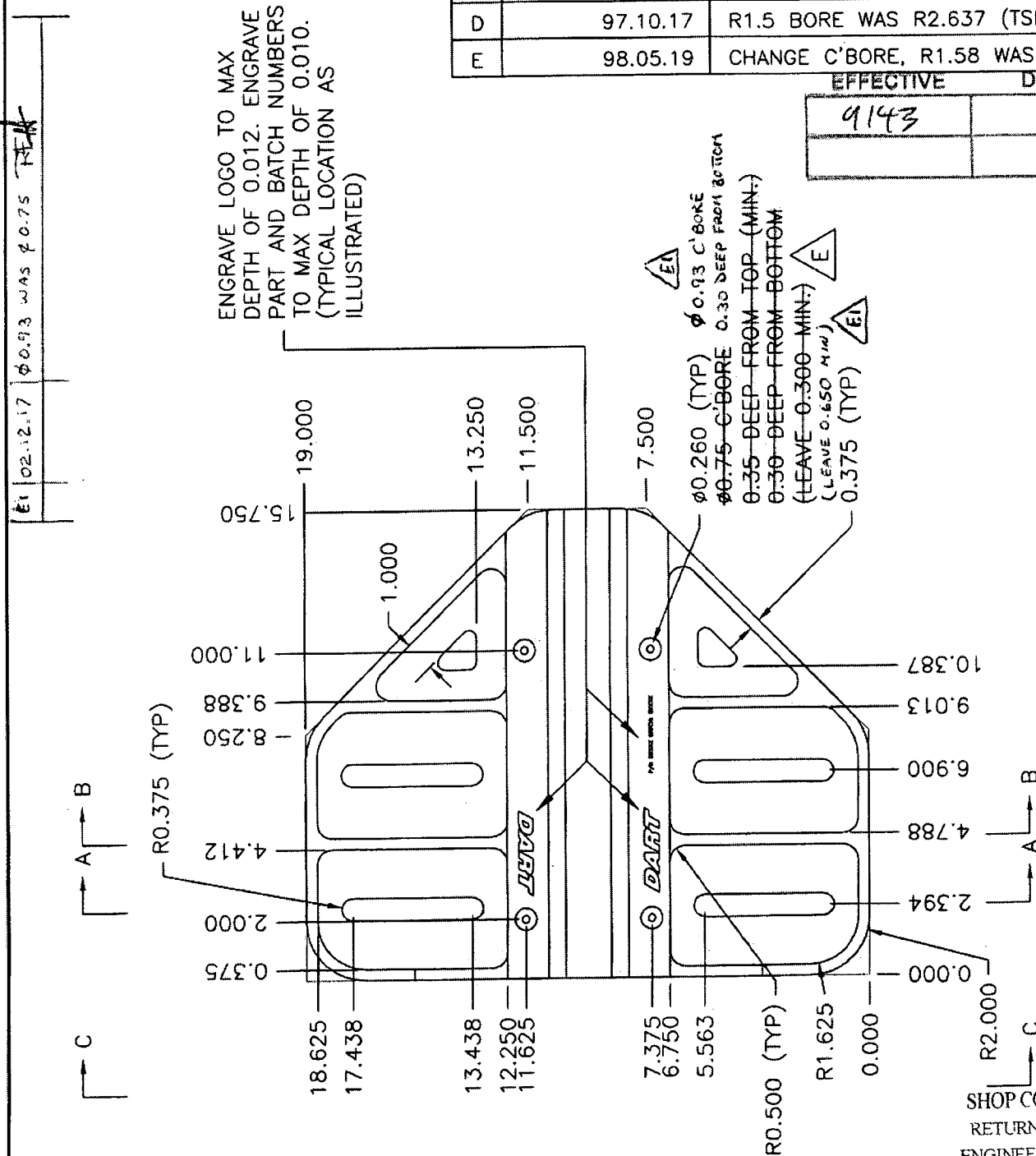
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <u>RF</u>	<u>RF</u>



DESIGN KE		DRAWN BY KE		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D2435 REV. E SHEET 1 OF 2	
DATE 98.05.19		TITLE BEARPAW		SCALE 1:5	
A	96.01.24	NEW ISSUE			
B	96.03.26	CHANGE BORE AND C'BORE DEPTH			
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED			
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)			
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50			

EFFECTIVE DEOs

9143



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING

~~UNCONTROLLED COPY~~

SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 2625

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

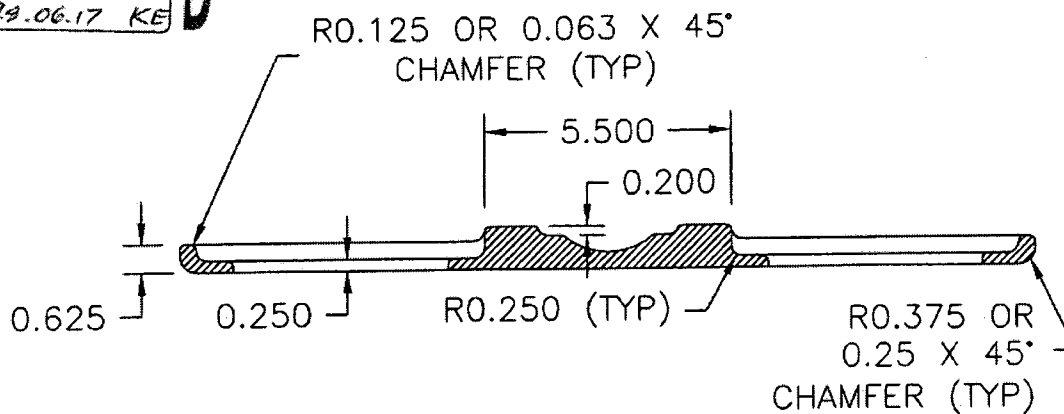
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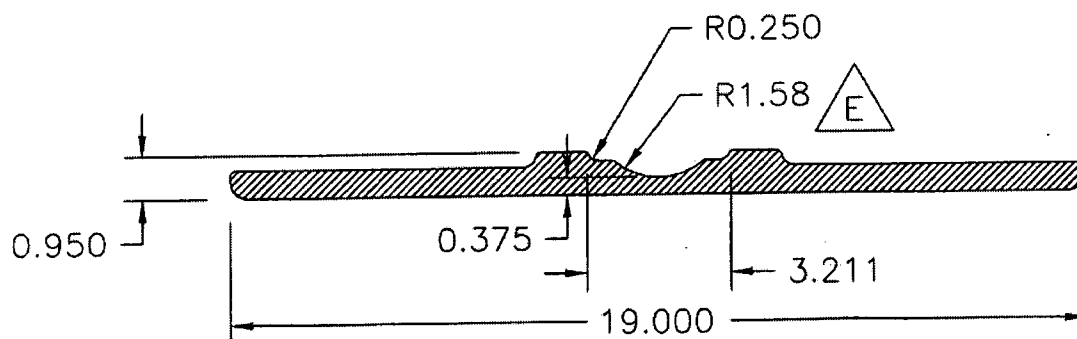


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DJB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

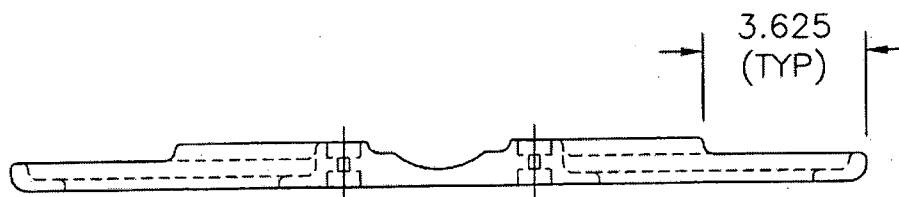
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
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W/O:		WORK ORDER CHANGES						
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